

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029516**Date Inspected:** 01-May-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** American Bridge Manufacture**Location:** Reedsport, Oregon

CWI Name:	Mike Inman and Tony Corsaletti			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	Skyway Traveler Rail Replacement		

Summary of Items Observed:

On this date CALTRANS OSM Quality Assurance (QA) representative was present at American Bridge Manufacture for observations related to welding, fabrication and Inspection performed for the Skyway Traveler Rail Replacement scheduled for this project. While onsite the QA Inspector observed the following.

At the time of arrival, the QA Inspector met with ABM Quality Control (QC) Inspector and discussed the welding operations and other items related to this project for this date.

Skyway Traveler Rail Replacement - CCO # 24S0

The QA Inspector periodically observed American Bridge Manufacture (ABM) welding personnel Mike Herbert and Joe Lacortt performing base material preparation and welding operations. The welding operation was being performed by using the Flux Cored Arc Welding Gas Shielded (FCAW-G) process in the flat position and it was being performed to make build-up (butter) incorrect cut material. The welding operation was being performed on assembly plate member identified as TR3031A and TR3034A scheduled to be incorporated into the Skyway Traveler Rail Replacement Assembly Mark # 3031TR1 and 3034TR1. The QC Inspector notified to QA Inspector, ABM has made a decision to build-up the cut notches instead of fitting the plate as is. Please see note below:

NOTE: The plates identified as TR3030, TR3031, TR3033 and TR3034 will be used for the Skyway Traveler Rail Replacement Assemblies listed above and were delivered to ABM from Farwest Steel in Eugene, Oregon with cut notches instead of cut bevels, a total of four notches were cut per plate and a total of four plates were delivered with the same discrepancy.

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The QA Inspector previously notified Structural Materials Representative (SMR) Adam Kreger (in behalf of Gary Thomas) and QA Task Leader Michael Foerder of the discrepancy mentioned above. SMR relayed to the QA Inspector the plate build-up will be acceptable as a plate repair for future fabrication.

The QA Inspector verified the electrical welding parameters and they appeared to be in general compliance with the referenced Welding Procedure Specification (WPS) number ABM-SAS-08. The QA Inspector observed QC Inspector monitoring the welding operation at this location. The welding operation was completed on the plates at this location during the QA Inspector's shift.

The QA Inspector was notified by QC Inspector ABM will continue the fabrication on these four plates and during the next shifts, ABM personnel will lay-out the plates to cut the bevels for the top and bottom welds as per shop drawings. The QA Inspector questioned Quality Control Manager David Speakman if any Non-Destructive Testing (NDT) will be performed at the locations where the welding build-up was performed. QCM relayed ABM technicians will perform Magnetic Particle Testing (MT) at these locations to make sure no welding discontinuities are present prior to continue the fabrication and welding. The MT testing was not performed on these plates during this shift.

Summary of Conversations:

As noted on the body of the report above

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

Inspected By:	Medina,Ricardo	Quality Assurance Inspector
Reviewed By:	Foerder,Mike	QA Reviewer
